

Work Order ID 63871

November 17, 2010 1:43:36 PM



Page 1

Item ID: D4154-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly

Start Date: 11/17/10 Start Qty: 2.00



Cust Item ID:

Required Date: 11/18/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4154

A

0.00

100



Large Fab

0.00

Memo

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154
2059 B Hardcoat Welding Rod
BATCH#: M 116044

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154
304 S.S. Welding Rod
BATCH#: M 114509

3-Transfer drill holes in bar

4- Use DT9684 to check fit after welding

EL 10/11/18

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

pl 10-11-18 (2x)

Work Order ID 63871

November 17, 2010 1:43:36 PM

Page 2

Item ID: D4154-041

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Setup Start

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Start Date: 11/17/10 Start Qty: 2.00

Required Date: 11/18/10 Req'd Qty: 2.00

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Schedule

*test between shifts look not bad.
Better than last set. Schedule*

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M112588

Memo

0.00

Powder Coating

START TIME: *7:45*
OVEN TEMPERATURE: *320°*
FINISH TIME: *8:15*

1 10-11-19

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

374 10/11/19

1 10/11/19

[Signature]

Work Order ID 63871

November 17, 2010 1:43:36 PM



Page 3

Item ID: D4154-041

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Setup Start



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Item Name: Wearplate Assembly

Start Date: 11/17/10 Start Qty: 2.00



Cust Item ID:

Required Date: 11/18/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start



QC: Date:

SPC (Y/N): Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00



Small Fab

Memo

0.00

Small Fab

1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3
dwg D4154.

M116210 (BLACK)

ml 10 . 11 . 23 ②

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

② 10 . 11 . 23 ②

170

Identify as per dwg & Stock Location: FP-9

0.00



Packaging

Memo

0.00

Packaging

ml 10/11/23

2 9

Work Order ID 63871

November 17, 2010 1:43:37 PM

Page 4

Item ID: D4154-041

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Revision ID:

Item Name: Wearplate Assembly

Start Date: 11/17/10 Start Qty: 2.00

Required Date: 11/18/10 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/11/23
MF
10-11-23

Picklist Print

November 17, 2010 1:43:34 PM

Page 1

Work Order ID: 63871

Parent Item: D4154-041

Parent Item Name: Wearplate Assembly



Start Date: 11/17/10

Required Date: 11/18/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.21 new issue DD verf:EC
10.11.04 added DT9684 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4154-1		Manufactured	No			100	Each	1.0000	1	2			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Plate



EL 10-11-18.

B62708x1

Location

WA

62199

Loc Qty

1

1

Loc Code

1

D4155-1		Manufactured	No			100	Each	2.0000	1	2			
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Bar



EL 10-11-17.

B63838 x2

Location

ST

60976

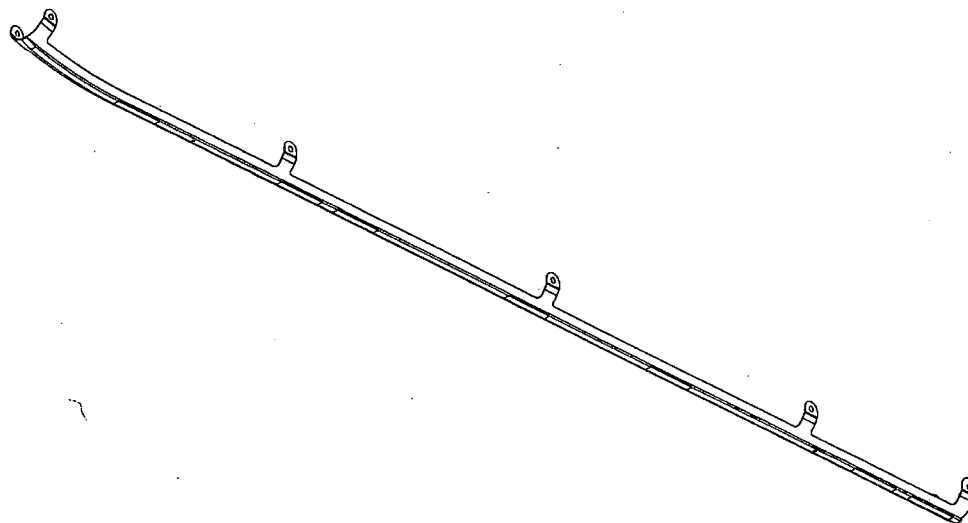
Loc Qty

2

2

Loc Code

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	PR 1422	SEALANT (SEE NOTE 11, SHT 2)

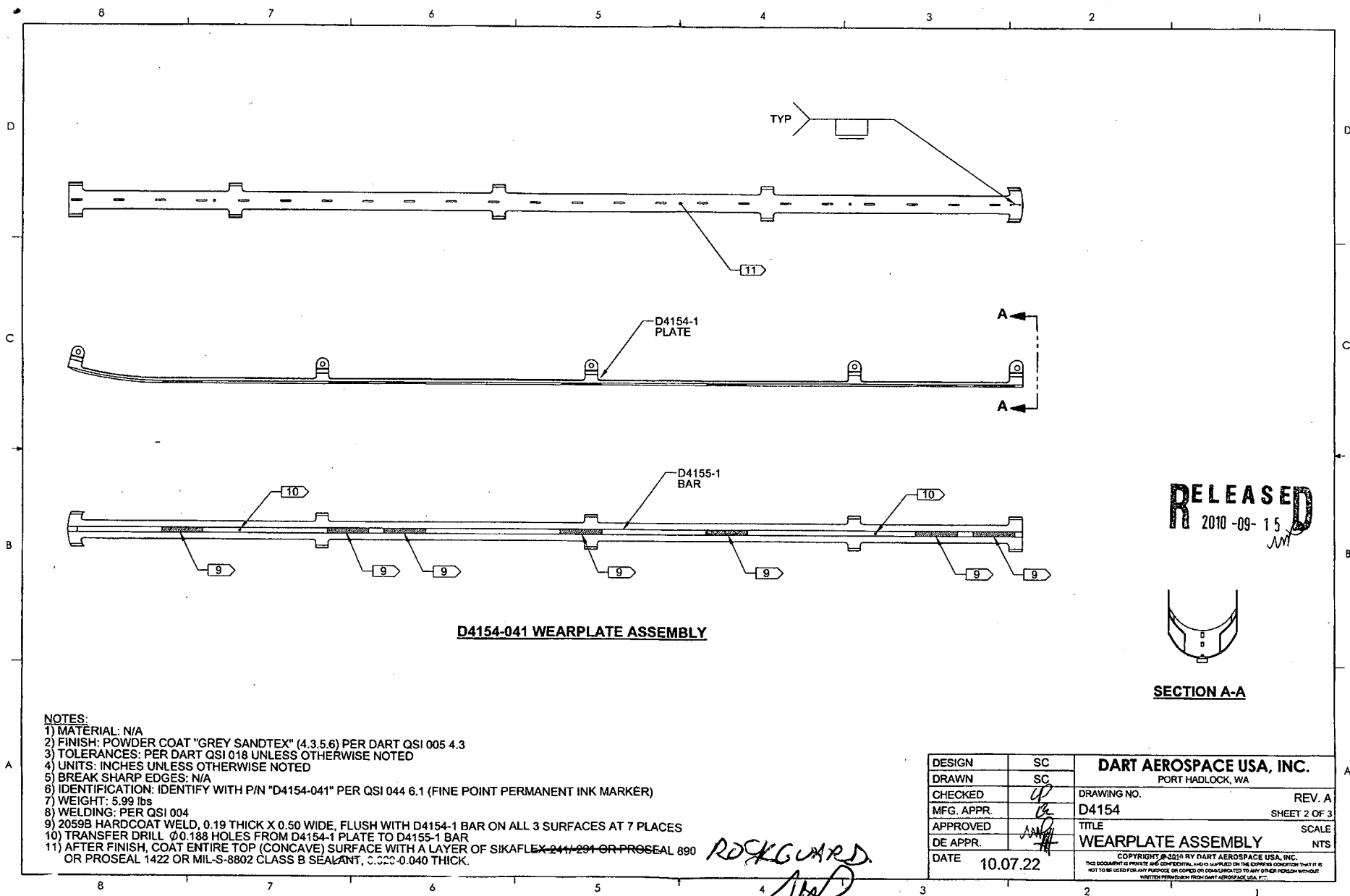


D4154-041 WEARPLATE ASSEMBLY

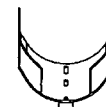
RELEASED
2010-09-15

cto 63871

A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4154	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSEMBLY	NTS
DATE	10.07.22	<small>COPYRIGHT © 2016 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



RELEASED
2010-09-15



SECTION A-A

NOTES:

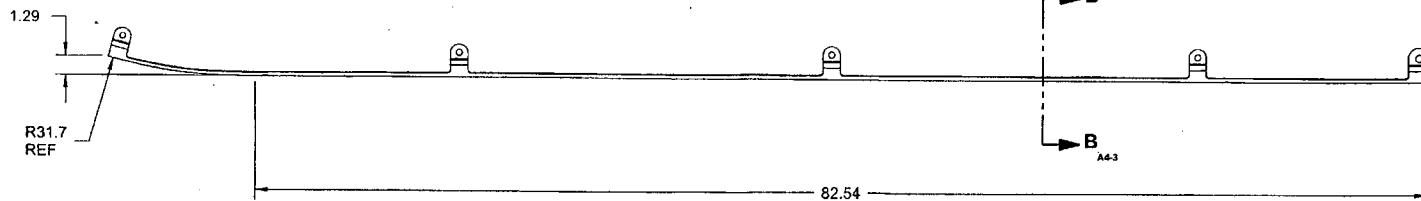
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 5.99 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
- 10) TRANSFER DRILL Ø0.188 HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) AFTER FINISH, COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF SIKAFLEX 2411/291 OR PROSEAL 890 OR PROSEAL 1422 OR MIL-S-8802 CLASS B SEALANT, 0.020-0.040 THICK.

DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4154	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSEMBLY	NTS
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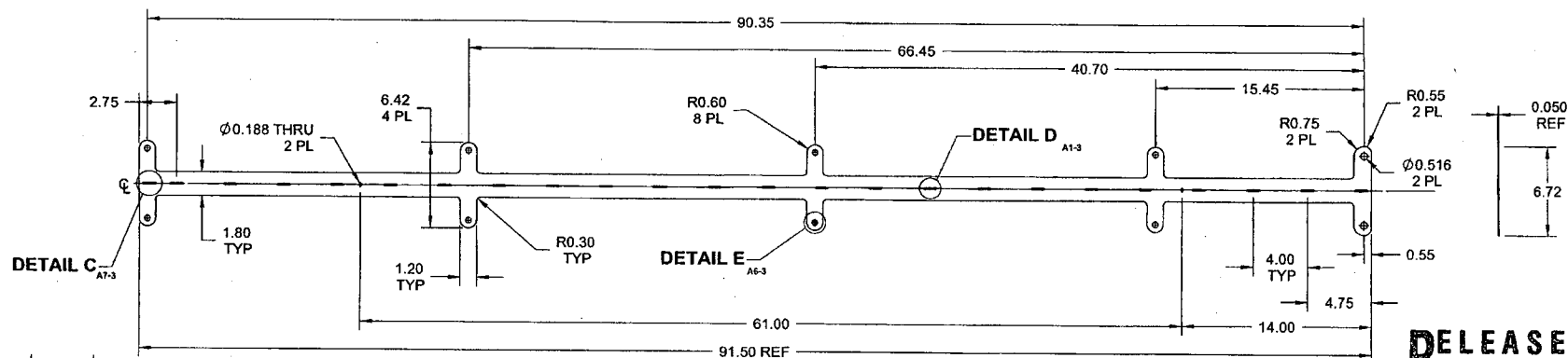
ROCK GUARD

10/11/23

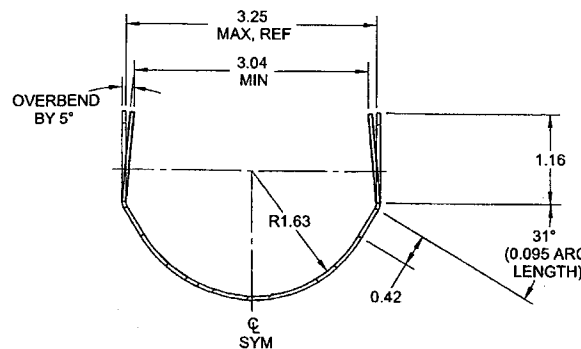
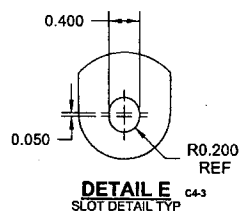
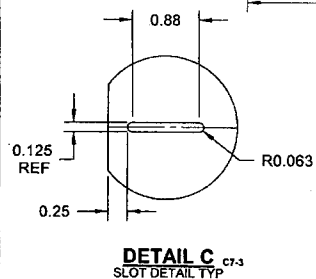
63871



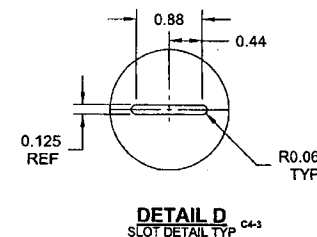
D4154-1 PLATE
(MAKE FROM D4154-1F)



D4154-1F FLAT PATTERN



SECTION B-B



- NOTES:**
- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
 - 2) FINISH : NONE
 - 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS : INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION : NONE
 - 7) WEIGHT : 2.71 lbs

DESIGN	SC	DART AEROSPACE USA, INC.	
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MFG. APPR.		D4154	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
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63871